

Date: Tuesday, 27/05/2008 9:07:09 AM
User: Linda Lacelle

Process Sheet

*split into
823 08 10 6/09*

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MIRROR ARM
Job Number : 39504 *2*
Estimate Number : 10505
P.O. Number :
This Issue : 27/05/2008 S.O. No. :
Prsht Rev. : NC Part Number : D2010103
First Issue : 1/1 Type : SMALL / MED FAB Drawing Number : D2010 PRELIM
Previous Run : 38795 Drawing Revision : PRELIM *08.05.30*
Written By : Material :
Checked & Approved By : Due Date : 03/06/2008 Qty: *20* Um: Eac
Comment : Est: F 02.08.21 Re-format; Added D2057 KJ/RF
Est Rev: G 08-05-27 as per ECN1195P DD verified by: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0500W049 304 RD Tube .500 x .049W



Comment: Qty.: 1.5750 f(s)/Unit Total: 31.5000 f(s)
Material: 304/316 SS tubing 0.500" Dia. x 0.049" wall
(M304TR0500W049) Batch No: *M107518 (14)* *08.05.30* *M108215*

2.0 BRAKE NC NC BRAKE



Comment: BRAKE NC
Punch per Dwg. D2010-103-T1 and Spec Control Dwg D2727
Identify as D2010-103 *SN 08/06/02*

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Bend as per Dwg D2010 using bending Jig D2010-103T2
2- Deburr ends *EP 08/06/02 (14) 20*

4.0 D2057 Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Plug

Pick:

Qty Part Number Description Batch
1 D2057 Plug *39661*
D2057

FF 08-06-09

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM

Job Number: 39504

Part Number: D2010103

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1		
1-flare before installing plug as per dwg D2010		
2-Install D2057 plug as per Dwg D2010		
6.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
7.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING		
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3		
START TIME: 10:40 am		
OVEN TEMPERATURE: 320 °C		
FINISH TIME: 11:20 am		
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT		
9.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1		
Identify and Stock		
Location: 51228		
10.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		

FF 08-06-12 (6)

5 08/06/12 (6)

M 10 2316

(6X)

M-1 08/06/12

F2 08/06/12

P 08/13 (6)

08/06/16

W 08.06.16

